

Work Order ID 75095

75095

Page 1

October-17-11 1:23:15 PM

Item ID: D2804-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 17/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/10/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								

100
100
 Small Fab
 Small Fab
 Small Fab

Small Fab
 Memo
 Press D2805-2 into arm as per Dwg D2804

0.00
 0.00

ES 11/11/24 (2)

110
110
 QC
 Quality Control

QC5- Inspect part completeness to step on W/O
 Memo

0.00
 0.00

Sulu/24

(72)

-042

120
120
 Powdercoat
 Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
 Memo

0.00
 0.00

START TIME: 8:00 OVEN TEMPERATURE:
 FINISH TIME: 8:30

2X M/L 11/11/24

W118439

320 OF

8:30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Press Fit D2809 as per Dwg D2804								
150	Small Fab	0.00							
150									
Small Fab	Memo	0.00							
Small Fab	1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.								

2 BR 11-11-29

EP 11/11/29 (2)

EP 11/11/29 (2)

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00				<u>m</u>	<u>11</u>	<u>11</u>	<u>29</u> (2)
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST 150</u>	0.00							
170									
Packaging	Memo	0.00							<u>SP 11-11-30</u>
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									<u>11/11/30</u> [Signature]
QC	Memo	0.00							
Quality Control									<u>mf</u> <u>11-11-30</u>

Dart Aerospace Ltd

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H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

October-17-11 1:23:20 PM

Page 1

Work Order ID: 75095

75095

Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2		Manufactured	No			100	Each	6.0000	1	2			
D2804-2									**				
Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST149		6							
				71571		6							
D2805-2		Manufactured	No			100	Each	0.0000	1	2			
D2805-2									**				
Stop													
NAS1515H3		Purchased	No			100	Each	115.0000	4	8			
NAS1515H3									**				
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST277		115							
				116373		6							
				118078		6							
				118384		103							
AN3C16A		Purchased	No			150	Each	62.0000	2	4			
AN3C16A									**				
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		62							
				115835		1							
				118422		36							
				118628		25							

M119438 (2x)

EP 11/11/24

EP 11/11/24

EP 11/11/25

EP 11/11/25

4

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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H:\FORMS\Quality Assurance\approved QANCRWO RevE

Picklist Print

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Work Order ID: 75095

75095

Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

D2809 Manufactured No

150 Each 37.0000

1

2

D2809

Bushing

**

Handwritten signature

Location

Loc Qty

Loc Code

GA

25

72735

25

ST023

12

34035

12

2

MS21043-3

Purchased No

150 Each 921.0000

2

4

MS21043-3

Nut

**

Handwritten signature

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

849

118077

1

118614

492

118686

356

Handwritten: 11/27/08
Handwritten: 40

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

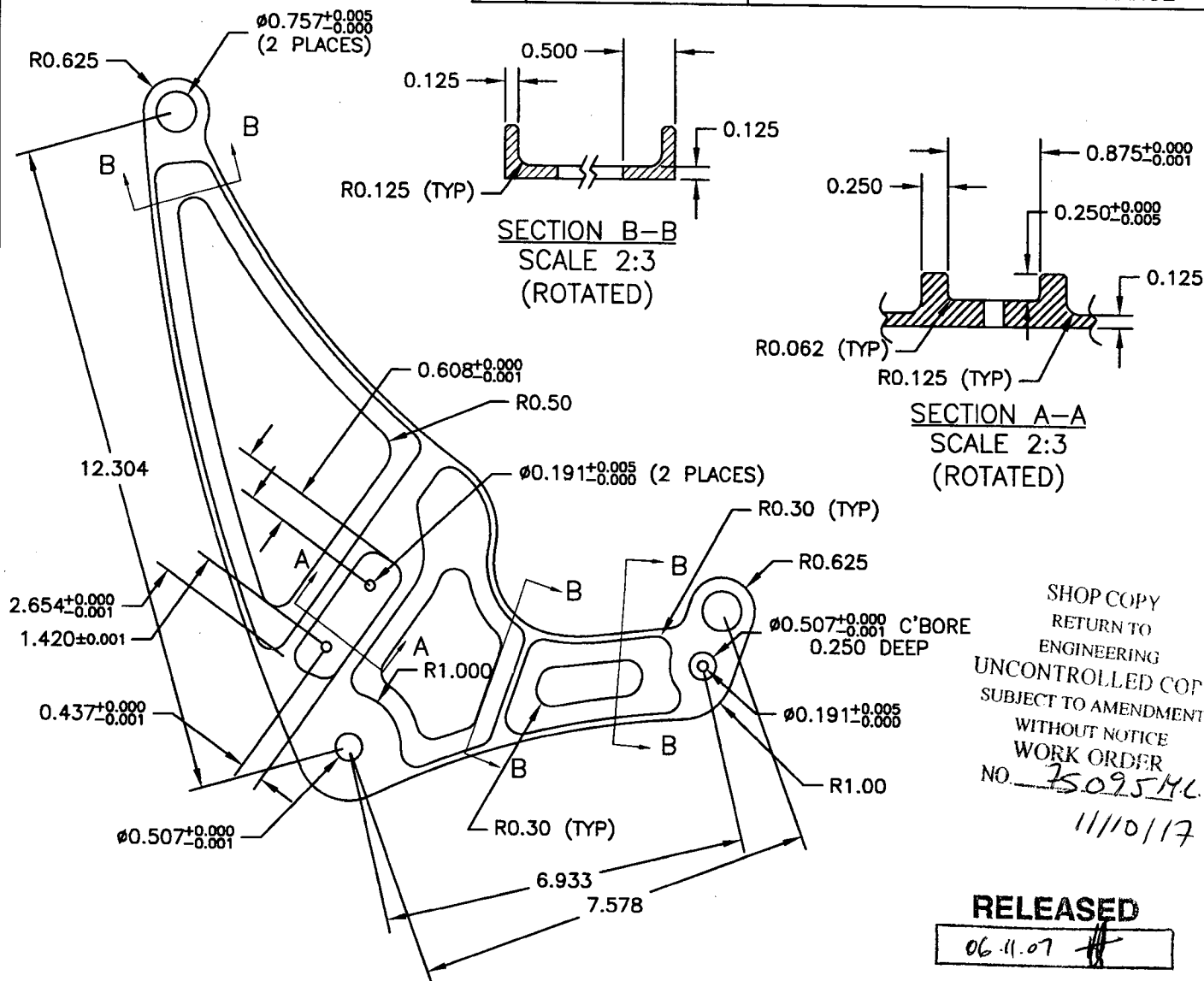
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. C
				D2804	SHEET 1 OF 2
DATE	06.10.16			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75095460
11/10/17

RELEASED

06.11.07 #

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRF"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

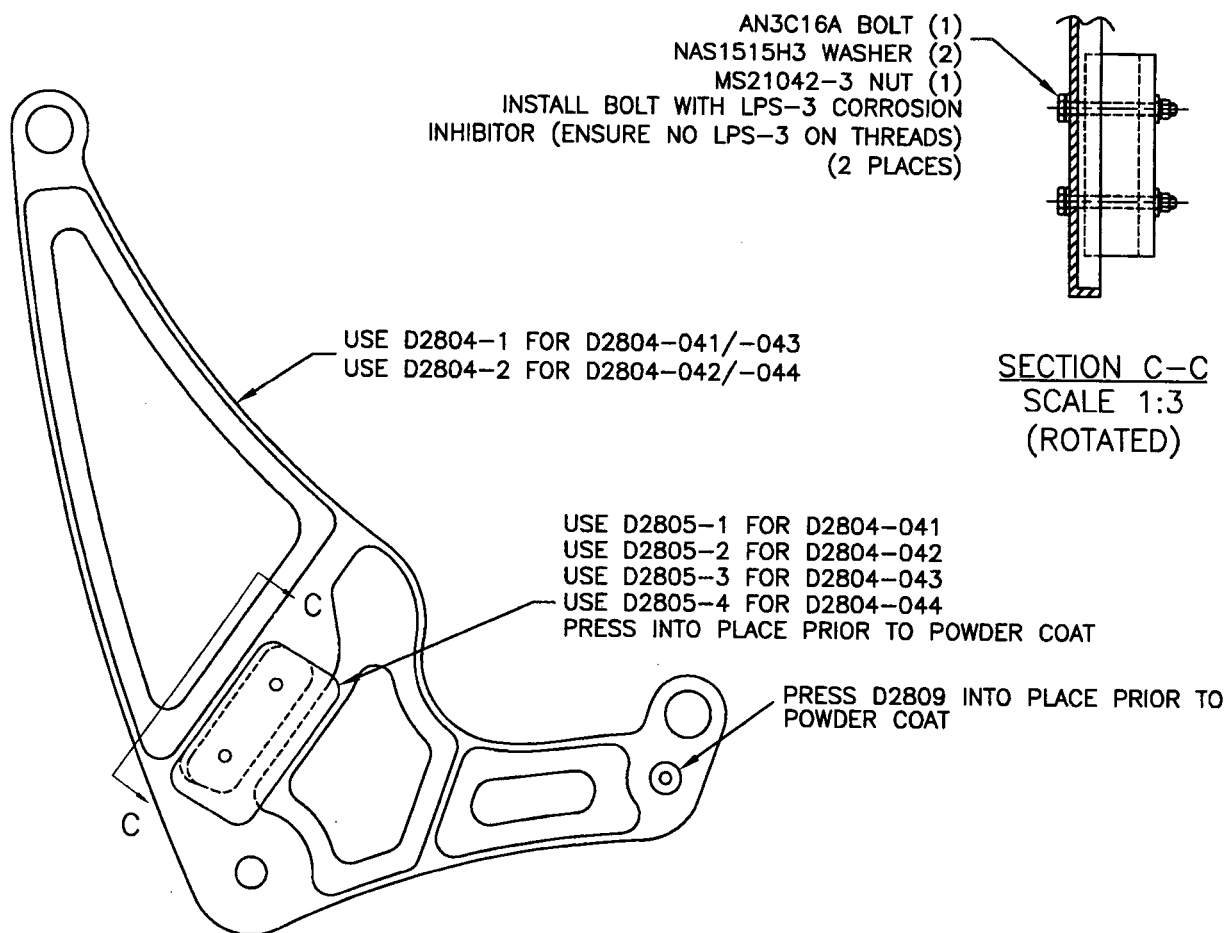
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

06.11.07 [Signature]

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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56095

Dart Aerospace Ltd

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